

Date: Thursday, 15/01/2009 11:13:42 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLEVIS
Job Number :	44791		
Estimate Number :	10578		
P.O. Number :		Part Number :	D34533
This Issue :	15/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3453 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	44587	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	10/02/2009
Written By :		Qty:	4
Checked & Approved By :	JUD 09.01.15	Um:	Each
Comment :	A 05.09.27 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	304 round bar 1.250
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Comment: Qty.: 0.2452 f(s)/Unit Total : 0.9808 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: 105872

09/01/16

4 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA578 Rev: AA & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

09/01/16

4 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/16

4 pcs

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA578 Rev: A & Dwg D3453 Rev: A
 2- Deburr as per dwg 3453

09/01/22

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/22

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:13:42 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 44791

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

JP 09/01/22 (4)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 09/01/22 (4)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/01/23 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl

JS 09/01/23 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/24 (4)

Job Completion



MF 09-01-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

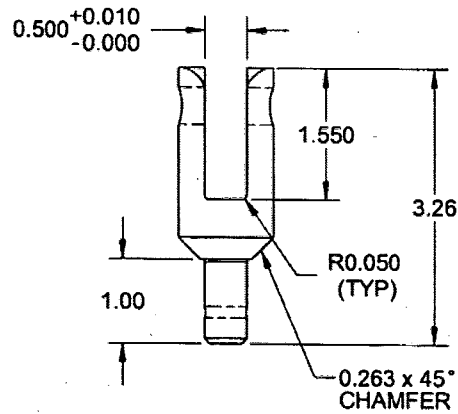
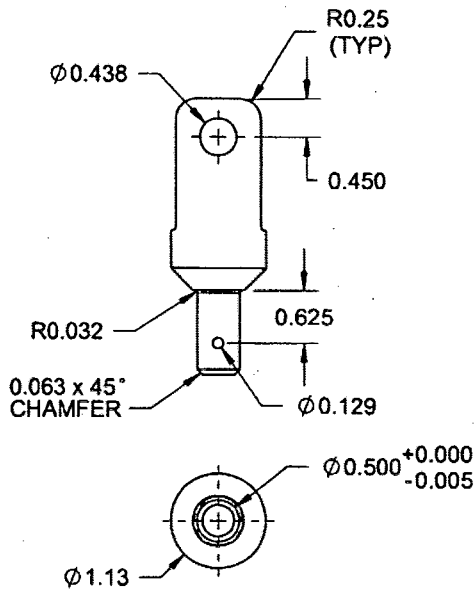
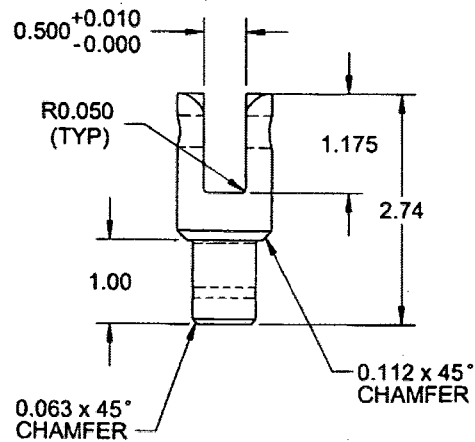
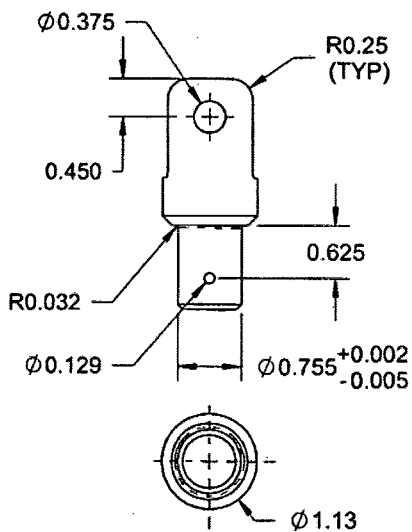
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

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DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 *[Signature]***D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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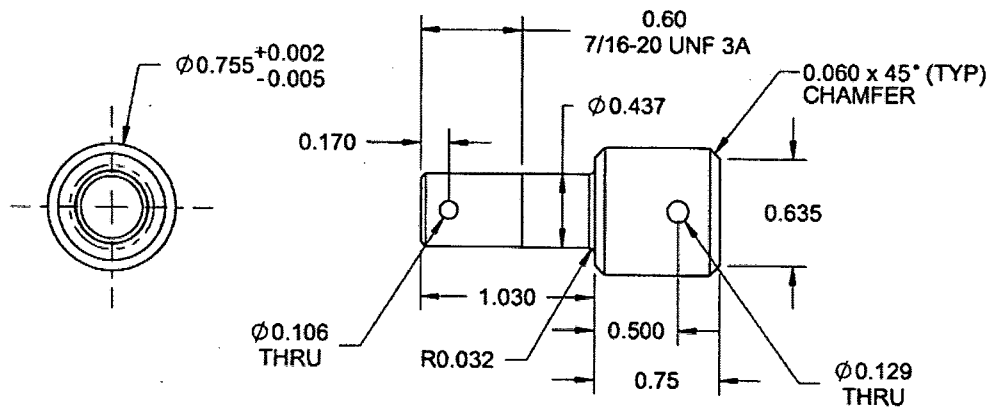
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DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 [Signature]

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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